



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5496-1

Job Sheet 181816



Part No: D5496-1

Job Qty: 10 ea

Part Name: Connector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5496 REV.B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/03 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Waterjet		SE 18/09/18
100	Waterjet	10 pcs	8/17/18	8/17/18	0.00	0.35	Waterjet1		SE 18/09/18
120	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Waterjet-4		SE 18/09/18
140	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC8-7		SEP 12 2018 68
150	HandFinish	10 pcs	8/17/18	8/17/18	0.00	1.00	HandFinish1		SA 18-09-18
155	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC7-5		
160	SprayPaint	10 pcs	8/17/18	8/17/18	0.00	1.00	Spray Paint		
170	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC14		
180	Packaging	10 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-1		
190	QC21-SA	10 Ea	8/17/18	8/17/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: 160 - Prime and paint as per dwg. ***MASK HOLES AS PER NOTE 8***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	.8000 sf (.08 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.250	1	30	0

Part Specifications

Specifications could not be found.

Plex 9/11/18 3:08 PM dart.leroux.jason



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S109397



Part: D5496-1

Job No: 181816

Serial No/Batch: S109397

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/12/16

DART AEROSPACE LTD		Work Order:	181816
Description: connector		Part Number:	D5496-1
Inspection Dwg: D5496	Rev: B	Page 1 of 1	

[illegible]

Engineering Approval: (If necessary)		Date:	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>D 181816</u> Part No. <u>D5496-1</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : <u>18-09-12</u>		Step #: <u>100</u>		QTY Effective : <u>10</u>			MRB (QSI042) Approval DAS 9 9-89 <u>18-09-12</u>		
Description Work Order Deviation				Disposition				Completed By DAS 63 9-89 <u>18/9/12</u>	
Thickness is .258", drawing calls for .250 $\pm .000$.250 $\pm .005$				Machine D5496-1 to drawing tolerance				Lead hand / Supervisor Approval Verification <u>AD 18-10-26</u>	
								QC / QA Coordinator Approval <u>AD 18-10-26</u>	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☒ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
☒ OTHER : <u>material.</u>									

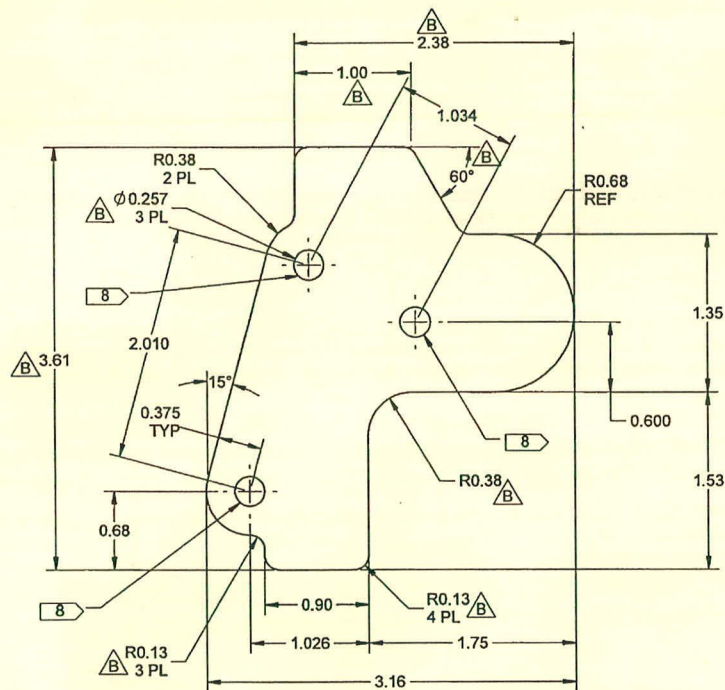


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1900

1900

1900



REFERENCE ONLY

B

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250" THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S0.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3 AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.030 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) MASK HOLES PRIOR TO PAINT

D5496-1 CONNECTOR

RELEASED

2018 JUL 30 NO
ECN 18-749

APPROVED

B	REMOVED -041; REVISED NOTES; REVISED CENTER HOLE; REVISED PART HEIGHT (ZN D8-1)	VS	18.05.23
A	NEW ISSUE	VS	18.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5496	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CONNECTOR	NTS
DATE	18.05.23	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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LEWIS & CLARK

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>181816</u> Part No. <u>DS496-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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